

Work Order ID 65643

Thursday, January 20, 2011 3:27:37 PM



Page 1

Item ID: D3290-3

Accept



Setup Start



Revision ID:

Item Name: Window

Stop



Start Date: 1/21/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 1/28/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: CMF

Date: 11-01-20 Tooling: _____ Date: _____

Run Start



QC: _____

Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
D3290	Rev C	

100



FLOW WATER JET

Waterjet

Memo

0.00

11-1-27

FLOW CNC Waterjet

1-Cut as per Dwg D3290
Deburr if necessary

0.00

Dwg Rev: C Prog Rev: C 2-

(9)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

11-1-27

Quality Control

Pro ⇒

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Sulz

(P) XZ

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 03290-3 PAR #: _____ Fault Category: Small Fabs/W-Tek NCR: Yes No DQA: _____ Date: 11/01/31
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 11/02/04 Date: 11/02/04

NCR: 65643		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/01/31	110	Found @ inspection that Qty ^{Qty x2} windows have chatter marks causing edges of window to have a very rough finish.	/ Scrap	→ Scrap Qty 2. No Replace.	11/11/31	/ 11/11/31	/ 11/11/31	/ 11/11/31
		R.L. Parts Flapping/other vibrations when water jet passing outside profile. Process	/ Scrap	/ / / / /			/ 11/10/12	/ 11/10/12

NOTE: Date & initial all entries

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Start Date: 1/21/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 1/28/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130

Operation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Without removing protective skin remove sharp edge by degurring.

x7

 11/02/02

140



THERMOFORMING MACHINE

0.00

Memo

0.00

Thermoform

1-THERMOFORM as per Drawing D3290 and Folio FTA001 Dwg.
Rev. C Folio Rev. B 2-Engrave part# &
batch#, (D3290-3)

x7

 11/02/02

150



QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Quality Control

x7

 11/02/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Item ID: D3290-3

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Setup Start



Revision ID:

Item Name: Window

Stop



Start Date: 1/21/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 1/28/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

+78

38

11/02/03

170



Thermoform

Thermoforming Machine

HAND FINISHING THERMOFORMING

0.00

Memo

0.00

Water sand and buff to remove scratches if required

(+7)

Dh
11/02/03

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S.11/02/03

(+7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 65643

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Setup Start



Revision ID:

Item Name: Window

Stop



Start Date: 1/21/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 1/28/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: _____

0.00



Packaging

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

MF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Page 1

Thursday, January 20, 2011 3:27:33 PM

Work Order ID: 65643



Parent Item: D3290-3



Parent Item Name: Window

Start Date: 1/21/2011

Required Date: 1/28/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP A 04.08.18 New issue KJ/RF

IPP B 06.05.09 Ecn 798 EC

IPP C 07.05.29 Thermoform in-house DL

IPP D 07.09.28 rev C dwg EC verified by: DD

IPP E 07.11.28 Add --Hand finish deburring DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.125 		Purchased		No		100	sf	190.9222	3	25.26316	32.	 B11-1-27	

1/8" Polycast II Sheet

Location	Loc Qty	Loc Code
MAT	190.9222	
113204	4	
114673	9.6722	
115338	177.25	

115338

(9)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	657643
Description: Window	Part Number:	D3290-3
Inspection Dwg: D3290	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>B</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	11-1-27	Date:	11-4-31	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD	

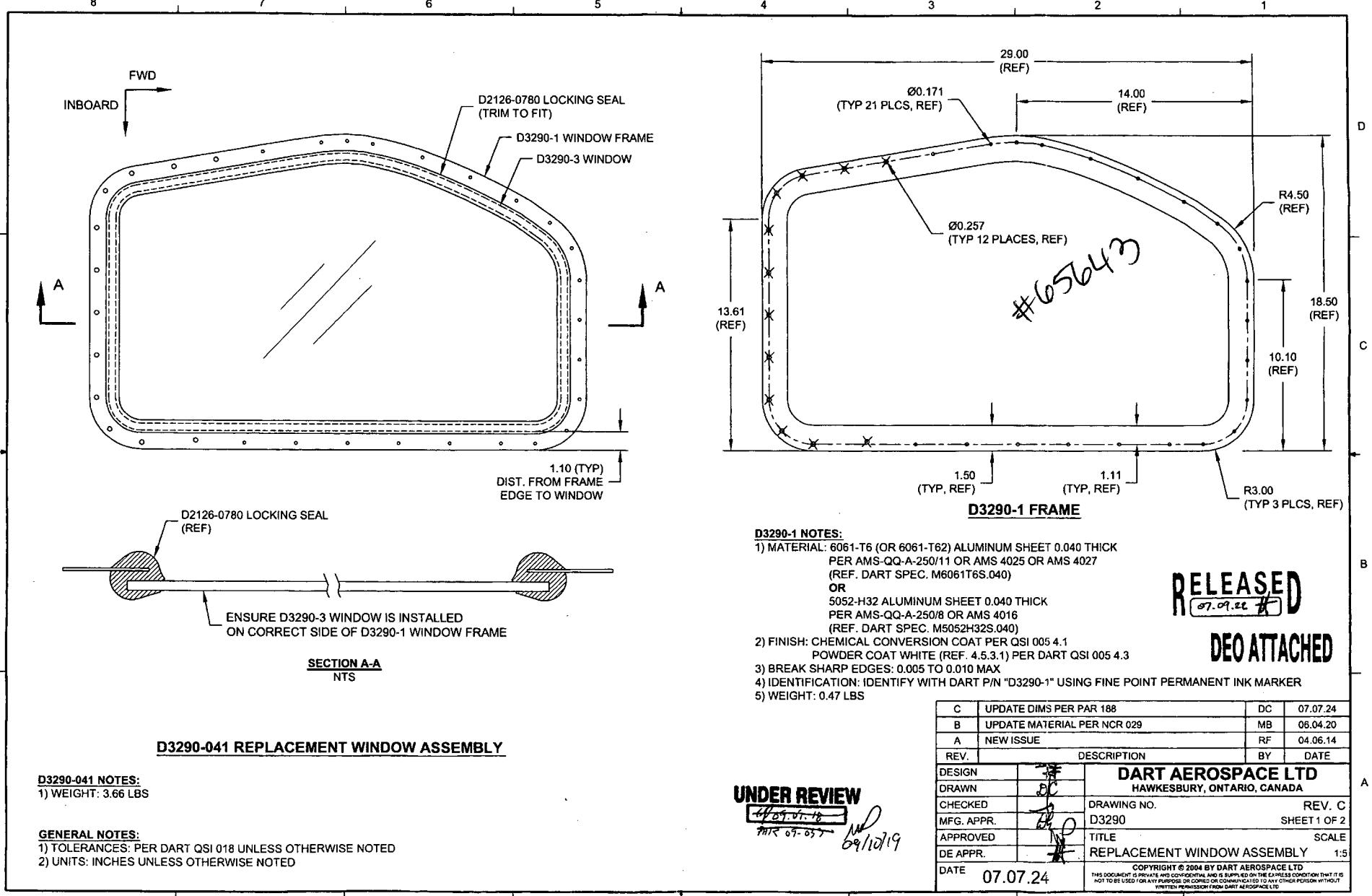
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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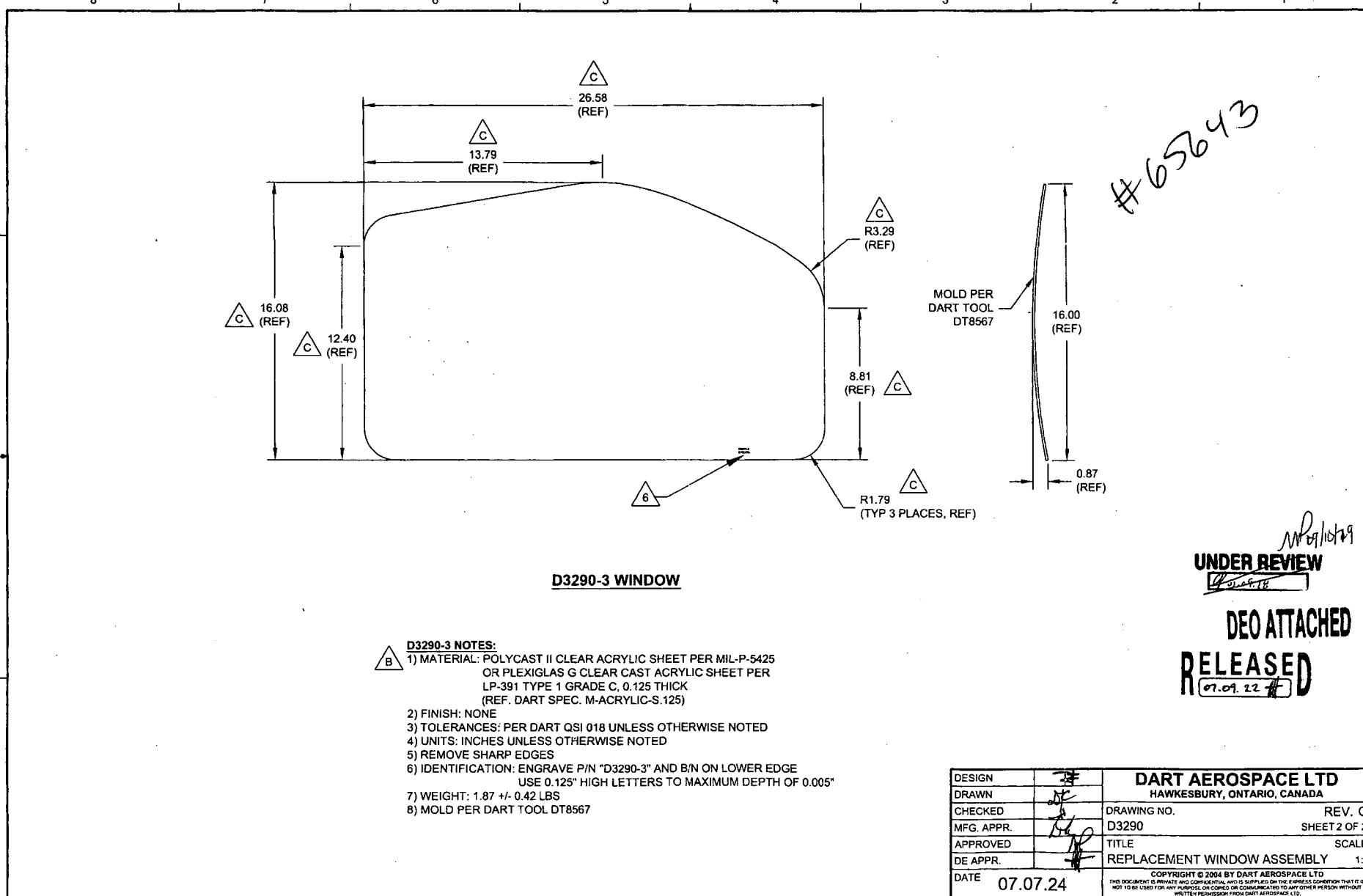
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DRAWING NO. D3290	TITLE REPLACEMENT WINDOW ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3290-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>90</i>	CHECKED <i>11</i>	MFG. APPR. <i>EZ</i>	APPROVED <i>MD</i>	DE APPR. <i>#</i>		
DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	

PURPOSE:

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

X/6502X3

D3290-1 NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK-0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)
 OR
 5052-H32 ALUMINUM SHEET 0.040 THICK-0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/8 OR AMS 4016
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

RELEASED
2009-10-09

WT

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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